



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-634-041
Job Sheet 171278



Part No: D205-634-041

Job Qty: 1 ea

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/30/18

Job Tracking No:

Due Date: 2/12/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD ver:EC IPP REV:R 12.01.23 AS PER ECN11-684 VER:EC IPP REV:S 17.12.08 REMOVE GASKET AS PER INTUITIVE INFO DD VER:FJS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/9/18	0.00	0.00	Start Up Skidtubes		M/G
110	CNC Bend Skidtubes	1 pcs		2/9/18	0.00	0.65	CNC Bend Skidtube		M/G
120	Skidtubes	1 pcs		2/10/18	0.00	2.89	Skidtubes-2		M/G
130	QC	1 pcs		2/10/18	0.00	0.00	QC5		DE
140	Skidtubes	1 pcs		2/10/18	0.00	2.89	Skidtubes-2		DE
150	QC	1 pcs		2/10/18	0.00	0.00	QC10		38
160	QC	1 pcs		2/10/18	0.00	0.00	QC5		9-89
170	HandFinish	1 pcs		2/10/18	0.00	1.31	HandFinish2		18-03-05
180	Powdercoat	1 pcs		2/10/18	0.00	0.34	Powdercoat1		18-3-02
190	QC	1 pcs		2/10/18	0.00	0.00	QC3		18-03-06
200	HandFinish	1 pcs		2/12/18	0.00	1.31	HandFinish4		DAS
210	QC	1 pcs		2/12/18	0.00	0.00	QC5		38
215	DC	1 pcs		2/12/18	0.00	0.00	DC		9-89
220	Packaging	1 pcs		2/12/18	0.00	0.00	Packaging3-1		DAS
230	QC21-FG	1 Ea		2/12/18	0.00	0.00	QC21		21

Part Op 110 - 1-Bend as per program D2580.C on CNC Bender and Fello 16 2-Cut tubes as per Dwg. D2580 3- scribe batch# in Descriptions: aft end of tube

120 - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004

140 - 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web.Deburr 6-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr 7-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

170 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180 - START TIME: 1:40pm OVEN TEMPERATURE: 320°F FINISH TIME: 2:15pm

200 - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 1188654 Sikaflex expire date: 18/04 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 1188654 Sikaflex expire date: 18/04 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: 1138761

210 - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

215 - Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG006

220 - Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 832-8200
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Container No: S046410



Part: D205-634-041
Job No: 171278
Serial No/Batch: S046410
Revision: H
Inspector:

Date: 02/28/18

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Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 Ea (1 ea)	90-Start up Operation	
D2576-3	Step (Machining Detail)	1 Ea (1 ea)	140-Skidtubes	
D4202-1	Spacer	20 Ea (20 ea)	140-Skidtubes	
ALS7-1032-130	Rivnut	50 Ea (50 ea)	200-HandFinish	5007279.
AN3-5A	Bolt	2 Ea (2 ea)	200-HandFinish	5013737-1
AN3C4A	Bolt	50 Ea (50 ea)	200-HandFinish	5019394
D2594-1	Plug	16 Ea (16 ea)	200-HandFinish	5025442 x11 5045769x8
D2594-3	O-Ring	16 Ea (16 ea)	200-HandFinish	5035836
D2855	Cap	1 Ea (1 ea)	200-HandFinish	F151613
D3564-11	Wearplate Aft	1 Ea (1 ea)	200-HandFinish	5027995
D3564-13	Wearpad Fwd	1 Ea (1 ea)	200-HandFinish	5041095
D3564-5	Wearplate Center	1 Ea (1 ea)	200-HandFinish	5026384
D3564-9	Wearplate Fwd	1 Ea (1 ea)	200-HandFinish	5045073
NAS1149C0332R	Washer	50 Ea (50 ea)	200-HandFinish	5044236
NAS1149D0332J	Washer	2 Ea (2 ea)	200-HandFinish	5020606
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2580-1 5042076	1	5	0
140-Skidtubes	D2576-3 8156023	1	45	0
	D4202-1 5030798	20	959	0
200-HandFinish	ALS4 ALS7-1032-130	50	0	0
	AN3-5A	2	263	0
	AN3C4A	50	1,944	0
	D2594-1	16	428	0
	D2594-3	16	581	0
	D2855	1	74	0
	D3564-11	1	22	0
	D3564-13	1	16	0
	D3564-5	1	32	0
	D3564-9	1	25	0
	NAS1149C0332R	50	2,621	0
	NAS1149D0332J	2	4,012	0
Part Specifications				
Specifications could not be found.				

Plex 2/7/18 8:18 AM Dart.Gagnon.Michelle

001464

ITEM	QTY -041	QTY -046	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
1	X				D2580-041	SKIDTUBE ASSEMBLY
2		X			D2580-045	SKIDTUBE ASSEMBLY
3			X		D2580-047	SKIDTUBE ASSEMBLY
4				X	D2580-049	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2500-1-190	EXTRUSION
21			16	16	D2570	BUSHING
22	1	1	1	1	D2576-3	STEP
23		4			D2579	SPACER
24	16	16	8	8	D2594-1	PLUG
25	16	16	8	8	D2594-3	O-RING
26	1	1	1	1	D2596	205 WEB
27	1	1	1	1	D2855	AFT CAP
28	1	1			D3564-5	WEARSHOE
29	1	1			D3564-9	WEARSHOE
30	1	1			D3564-11	WEARSHOE
31	1	1			D3564-13	WEARSHOE
32	20	20	24	24	D4202-1	SPACER
33			1		D4406-041	WEARPLATE ASSEMBLY
34			1		D4406-043	WEARPLATE ASSEMBLY
35				1	D5061-1	FWD WEARPLATE
36				1	D5061-3	AFT WEARPLATE
50	50	50			AL57-1032-130 or AK57-1032-130 or AK54-1032-130 or AELS-1032-130	INSERT
51	50	50			AN3C4A	BOLT
52	2	2	2	2	AN3-5A	BOLT
53			8	8	AN4-45A	BOLT
54	50	50			NAS1149C0332R	WASHER (AN960C10L)
55	2	2	2	2	NAS1149D0332J	WASHER (AN960D10L)
56			8	8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT (-045) GREEN SANDTEX (REF 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 33.7 lbs
D2580-045 = 33.7 lbs
D2580-047 = 45.1 lbs
D2580-049 = 32.0 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL AL57-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241-291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-049)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 171278 MCO
1808-07

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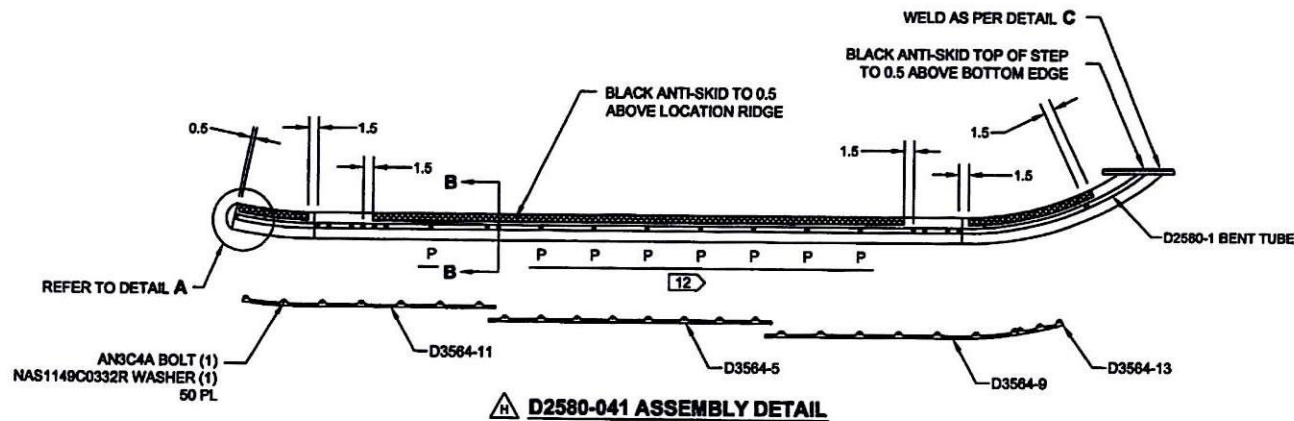
2017 JUL 05 4
ECN17-SUR

H	SHEET : PL DELETE D3566-1/-5/-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -048, -047 WEIGHT UPDATED PER DSI 9596	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PART12-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/ 9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9084/ 9097	CP	06.08.26
B	AS MANUFACTURED	DS	06.12.02
A	NEW ISSUE	DS	06.06.16
REV.	DESCRIPTION	BY	DATE
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DRAWN	SAD		
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MFG. APPR.			
APPROVED			
DE APPR.			
DATE	17.06.09		

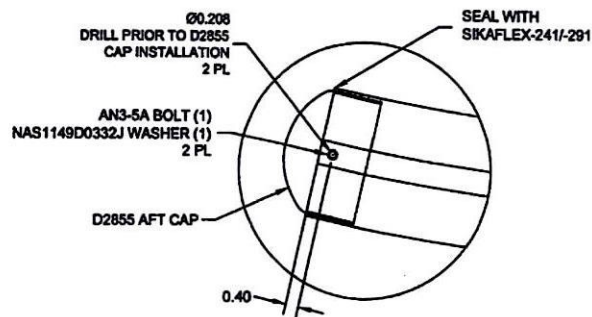
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2580
REV. H
SHEET 1 OF 9
TITLE 205 SKIDTUBE ASSEMBLY
SCALE NTS

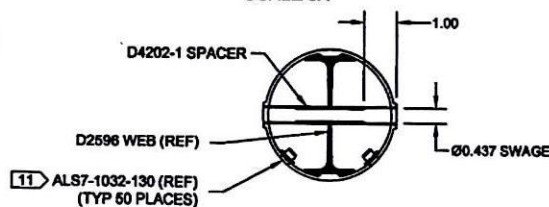
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DETAIL A
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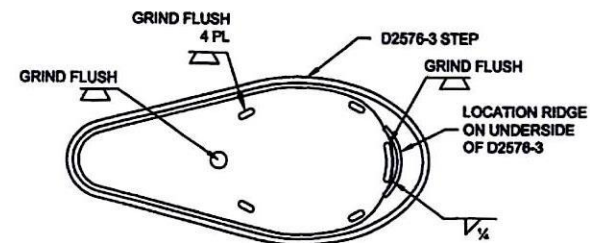


SECTION B-B
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

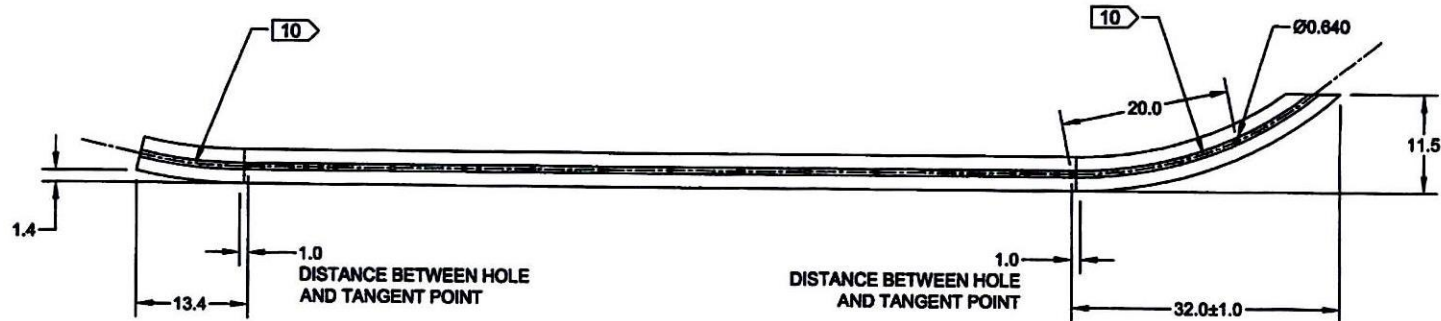
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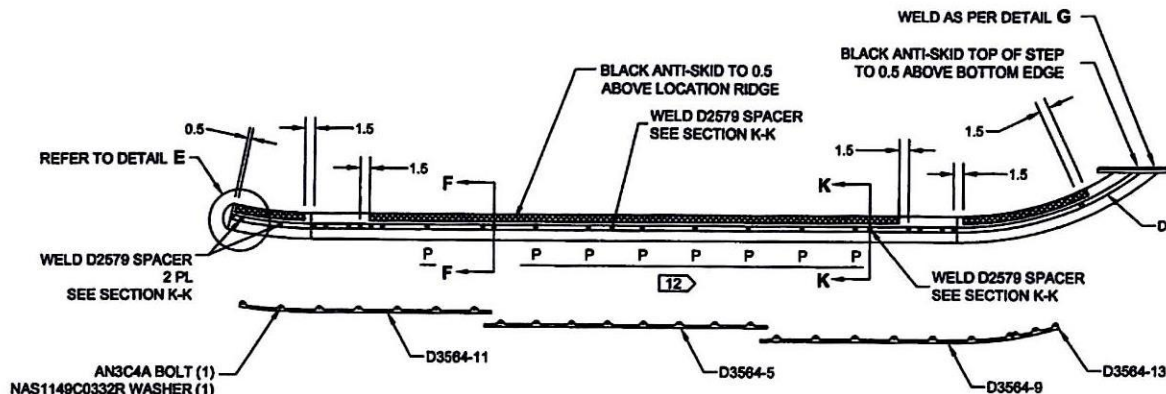
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MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 2 OF 9
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DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

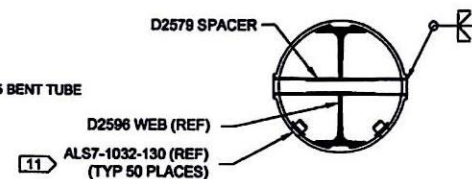
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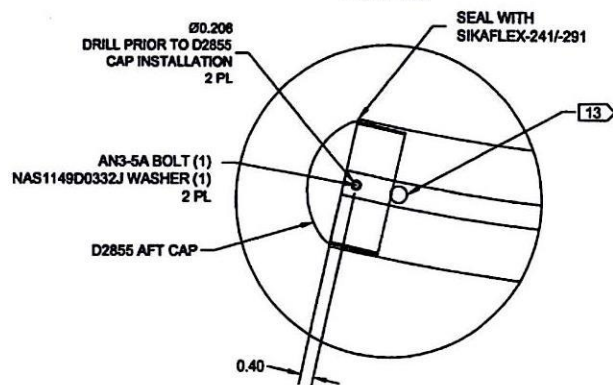
D2580-045 ASSEMBLY DETAIL

**SECTION K-K
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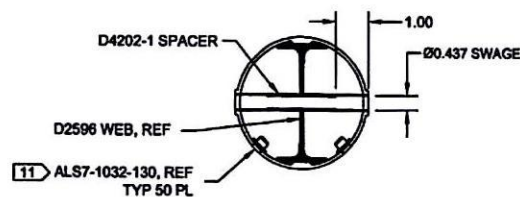


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (4 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. DO NOT C'BORE

**DETAIL E
SCALE 5X**

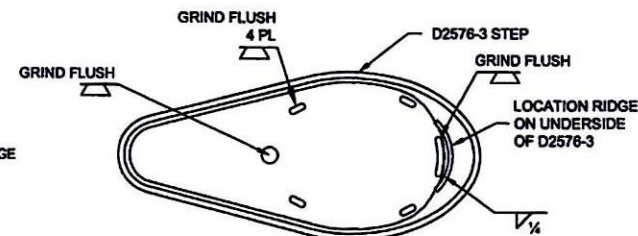


**SECTION F-F
SCALE 5X**



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

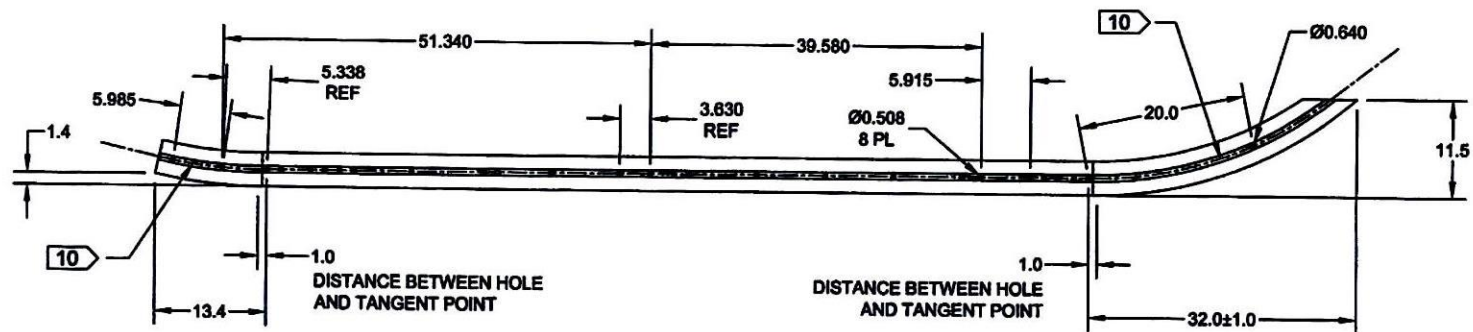
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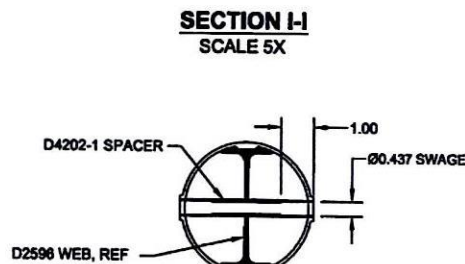
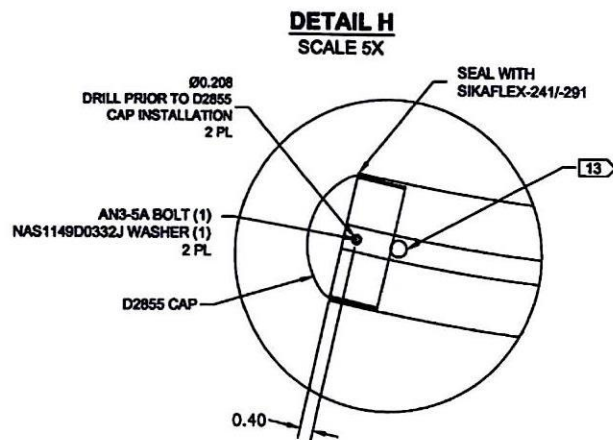
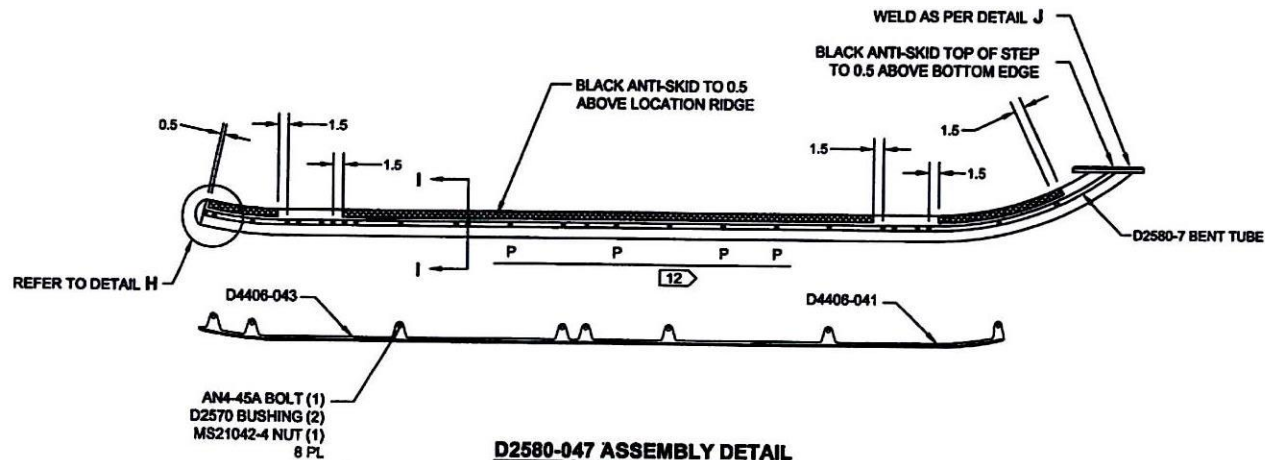


D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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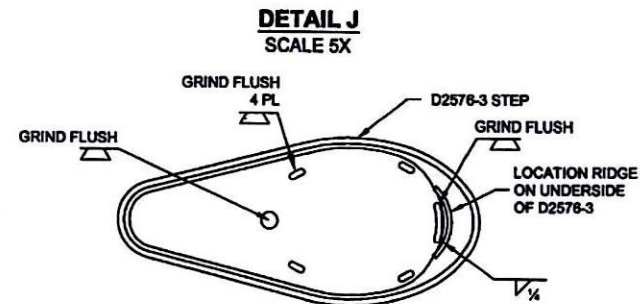
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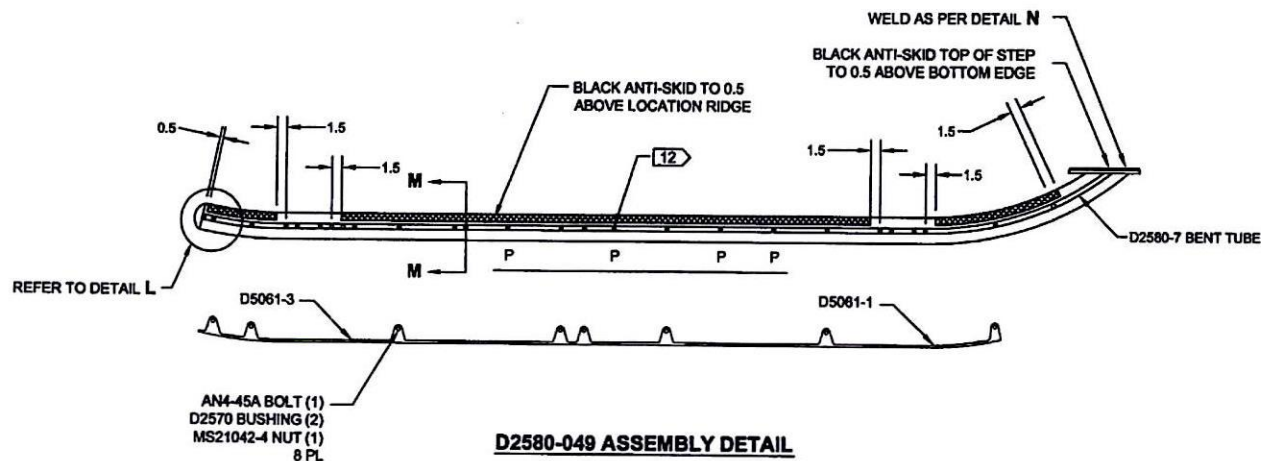
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



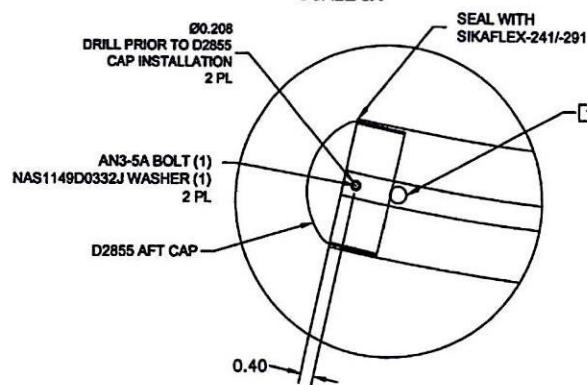
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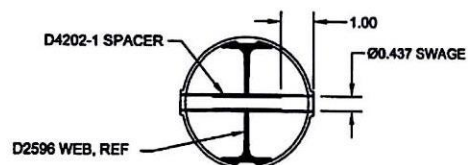
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MFG. APPR.		D2580	SHEET 8 OF 9
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DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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DETAIL L
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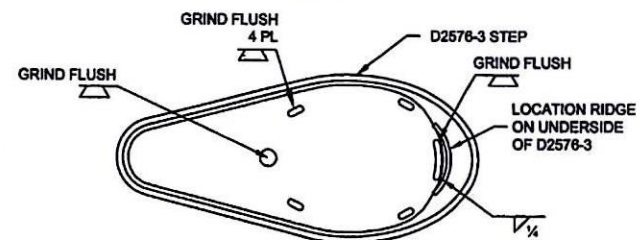


SECTION M-M
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

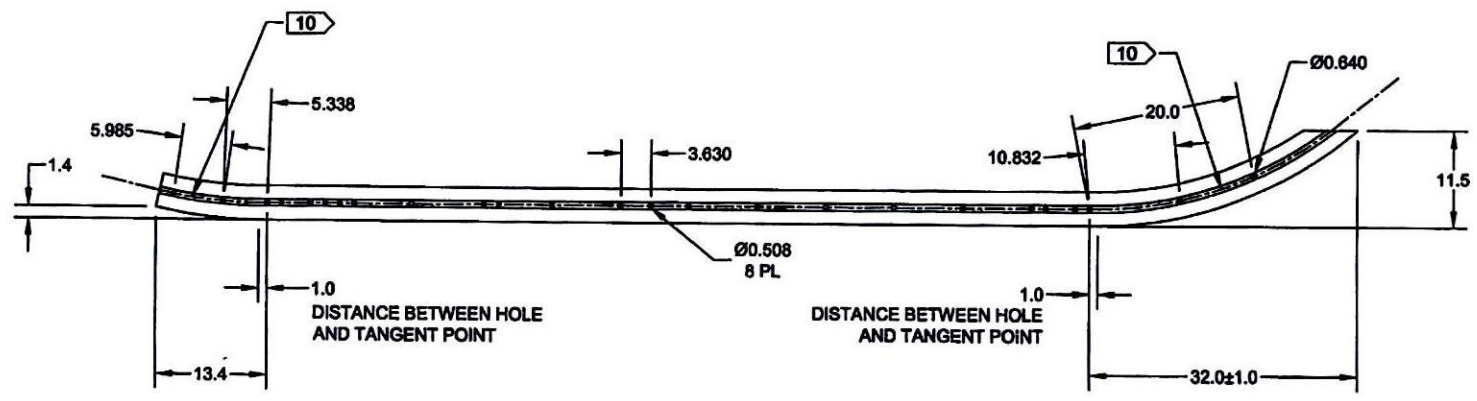
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SCALE 5X



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2017 JUL 05 up

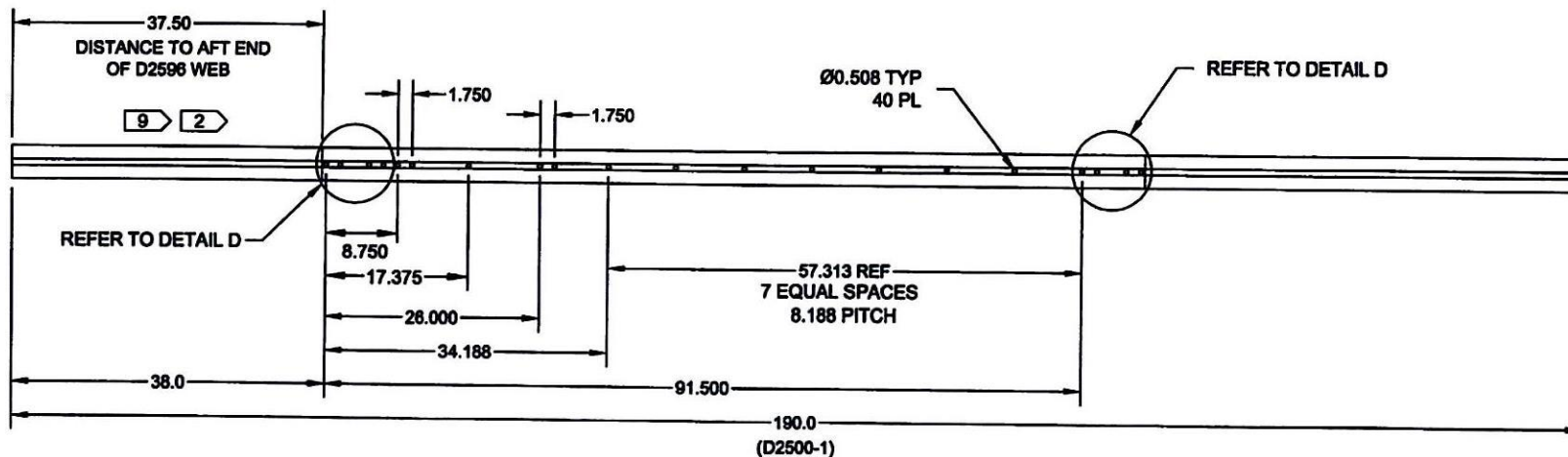
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 7 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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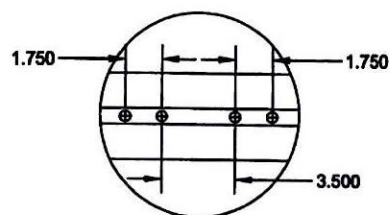
D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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D2580-101 TUBE



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